Work Order ID 57974

April 21, 2010, 9:54:32 AM

Item ID: D4038-10

Revision ID:

Item Name: Block

Accept

Setup **Start**

Stop

Start Date: 23/04/2010 **Start Qty:** 4.00

Required Date: 30/04/2010 **Req'd Qty:** 4.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run **Start**

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D4038	B

100		0.00							
Bandsaw	**Memo**	0.00				4	Ø		
Jeaspa Bandsaw	CUT BLANK 1.750" LONG		*mk 10/04/24*						
105		0.00							
HAAS 1	**Memo**	0.00				4	Ø		
HAAS CNC vertical machine #1	Mill as per Dwg and Folio FA885		*mk 10/04/26*						
	DWG REV: B								
	FOLIO REV: AA								
	DEBURR								

April 21, 2010 9:54:32 AM

Item ID:	D4038-10		Accept				Setup	Start	
Revision ID:									
Item Name:	Block							Stop	
Start Date:	23/04/2010	**Start Qty:** 4.00			**Cust Item ID:**				
Required Date:	30/04/2010	**Req'd Qty:** 4.00			**Customer:**				
Reference:							Run	Start	
Approvals:	**Process Plan:**		**Date:**	**Tooling:**		**Date:**			
	QC:		**Date:**	**SPC (Y/N):**		**Date:**		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	*Cwf 10/04/26*			4	Ø		
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	*B.A 10/04/26*			4	Ø		
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	*9V 10/04/27*			4	Ø		

Work Order ID 57974

April 21, 2010 9:54:32 AM

Item ID:	D4038-10		Accept		Setup	Start

Revision ID:

Item Name: Block Stop

Start Date: 23/04/2010 **Start Qty:** 4.00

Required Date: 30/04/2010 **Req'd Qty:** 4.00

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:** **Run** **Start**

  QC: **Date:** **SPC (Y/N):** **Date:** **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00				④			BR 10-4-27
QC Quality Control	Memo	0.00							
160	Identify as per dwg & Stock Location: 116	0.00							Pel4/pn ④
Packaging Packaging	Memo	0.00							
170	QC21- Final Inspection - Work Order Release	0.00							10/04/28
QC Quality Control	Memo	0.00							BJ 10-4-27 ④

Picklist Print

April 21, 2010 9:54:31 AM

Work Order ID: 57974

Parent Item: D4038-10

Parent Item Name: Block

Comments: Ipp Rev:A New Issue 09-12-14 JLM Verified By:EC

Start Date: 23/04/2010   **Required Date:** 30/04/2010

Start Qty: 4.00   **Required Qty:** 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.500X02.000		Purchased	No				f	9.5000	0.6989			

6061-T6 Bar 1.50 x 2.00

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT10	9.5	
110167	9.5	

.6989 *mk 10/04/24*

DART AEROSPACE LTD		Work Order: 57974
Description: BLOCK		Part Number: D4038-10
Inspection Dwg: D4038 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] **First Article**   [ ] **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.30	±.030	1.300	✓			
R.13	±.030	R.125	✓			
~~						
R.25	±.030	R.250	✓			
1.75	±.030	1.752	✓			
.708	±.005	.708	✓			
.542	±.010	.542	✓			
Ø.316	±.006/-.001	Ø.316	✓			
.500	±.005	.500	✓			
1.000	±.010	.998	✓			
1.35	±.030	1.350	✓			
.50	±.030	.502	✓			
.50	±.030	.506	✓			
Ø.189	±.005/-.000	Ø.191	✓			
Ø.50 X.50 DEEP	±.030 X ±.030	Ø.500 X.501	✓			

Measured by:	(signature)	Audited by:	B.A	Prototype Approval:	N/A
Date:	10/04/26	Date:	10/04/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

0.50 /B\
REF

0.50 /B\
REF

⌀0.189 THRU
C'BORE ⌀0.50 X 0.50 DEEP

6

D4038-10

/B\ 1.66

⌀0.316

R0.25

0.708 /B\   0.542 /B\

1.75

1.30

1.000

0.500

1.35 /B\

R0.13
2 PL

W/057974

RELEASED
2010 -04- 1 4
MP
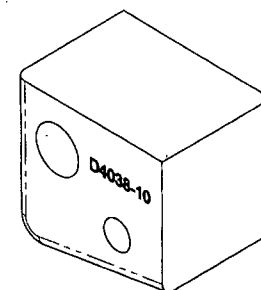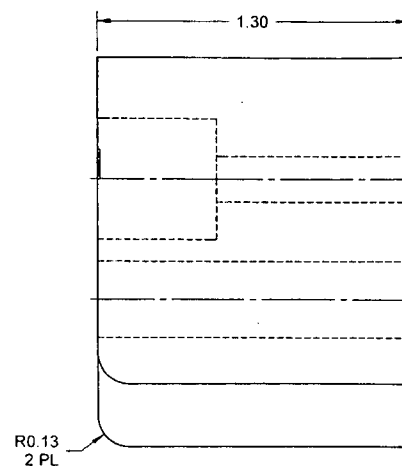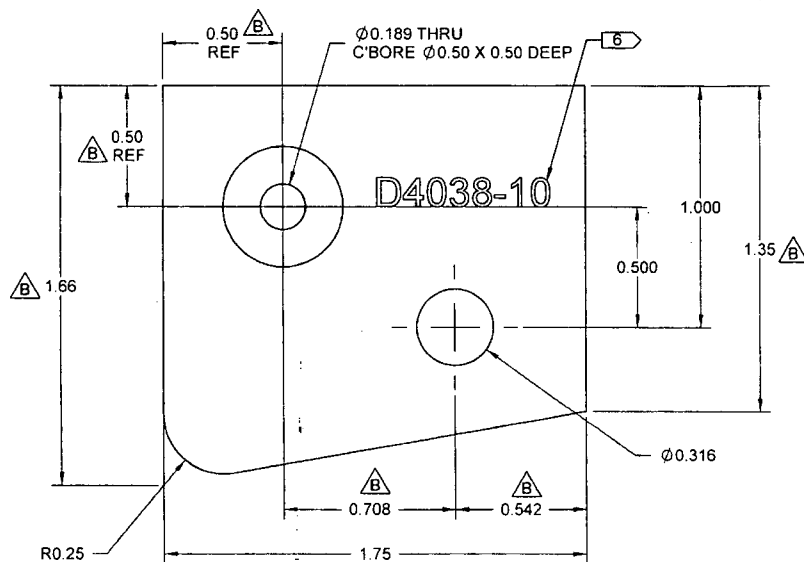
D4038-10 BLOCK

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
          PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
          PER AMS-QQ-A-200/8 (OR AMS 4160)
          REF DART SPEC M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
          OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
7) WEIGHT: 0.31 lbs

DESIGN		**DART AEROSPACE LTD**	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4038	SHEET 12 OF 14
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	10.01.05	COPYRIGHT © 2009 BY DART AEROSPACE LTD	